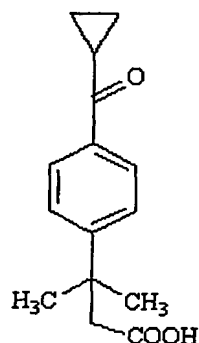
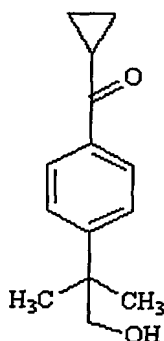


WE CLAIM:

- 1 1. A process for the preparation of cyclopropyl keto α, α -dimethylphenyl acetic acid
2 of Formula I,

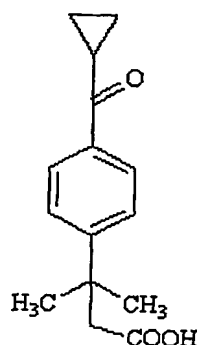
**FORMULA I**

- 3 the process comprising treating 4-(cyclopropyloxomethyl)-2,2-dimethylphenethyl
4 alcohol of Formula III,

**FORMULA III**

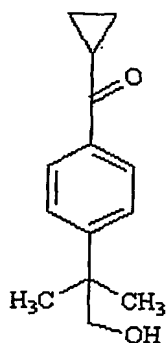
- 5 with a hydroxide of an alkali metal; adding oxidizing agent followed by aqueous
6 acidic work up; and isolating the cyclopropyl keto α, α -dimethylphenyl acetic acid.
- 1 2. The process of claim 1, wherein the hydroxide of an alkali metal is lithium
2 hydroxide, sodium hydroxide, and potassium hydroxide.
- 1 3. The process of claim 2, wherein the hydroxide of an alkali metal is sodium
2 hydroxide.

- 1 4. The process of claim 1, wherein the oxidizing agent is potassium permanganate.
- 1 5. The process of claim 1, wherein the oxidizing agent is added in small lots.
- 1 6. A process for the preparation of cyclopropyl keto α , α -dimethylphenyl acetic acid
2 of Formula I,



FORMULA I

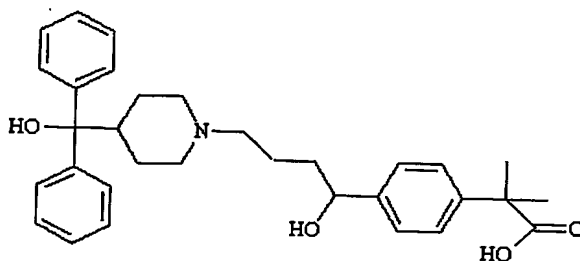
- 3 the process comprising treating 4-(cyclopropylloxomethyl)-2,2-dimethylphenethyl
4 alcohol of Formula III,



FORMULA III

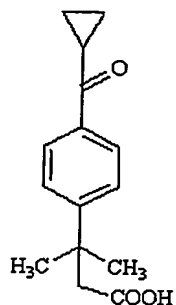
- 5 with a hydroxide of an alkali metal; adding oxidizing agent; adding organic solvent
6 followed by aqueous acidic work up; and isolating the cyclopropyl keto α , α -
7 dimethylphenyl acetic acid.
- 1 7. The process of claim 6, wherein the hydroxide of an alkali metal is lithium
2 hydroxide, sodium hydroxide, and potassium hydroxide.

- 1 8. The process of claim 7, wherein the hydroxide of an alkali metal is sodium
2 hydroxide.
- 1 9. The process of claim 6, wherein the oxidizing agent is potassium permanganate.
- 1 10. The process of claim 6, wherein the oxidizing agent is added in small lots.
- 1 11. The process of claim 6, wherein the organic solvent comprises one or more of
2 chlorinated hydrocarbon, ketone, or mixtures thereof.
- 1 12. The process of claim 11, wherein the ketone comprises one or more of acetone,
2 methyl ethyl ketone, and methyl isobutyl ketone.
- 1 13. The process of claim 12, wherein the ketone is acetone.
- 1 14. The process of claim 11, wherein the chlorinated hydrocarbon comprises one or
2 more of dichloromethane, chloroform, and 1,2-dichloroethane.
- 1 15. The process of claim 6, further comprising removing precipitated inorganic solids
2 after adding organic solvent.
- 1 16. The process of claim 15, wherein the inorganic solids are removed by filtration.
- 1 17. The process of claim 16, further comprising washing filtrate with one or more of a
2 chlorinated solvent after removal of the inorganic solids.
- 1 18. The process of claim 17, wherein the chlorinated hydrocarbon comprises one or
2 more of dichloromethane, chloroform, and 1,2-dichloroethane.
- 1 19. A process for the preparation of fexofenadine of Formula II or a pharmaceutically
2 acceptable salt thereof,



FORMULA II

3 the process comprising hydrolyzing the cyclopropyl keto α , α -dimethylphenyl
4 acetic acid of Formula I prepared by the process of claim 1 or 6, condensing with



FORMULA I

5 azacyclonol, and reducing.

1 20. A method of treating allergic reactions in a patient in need thereof, the method
2 comprising providing a dosage form to said patient that includes fexofenadine
3 hydrochloride prepared by the process of claim 19.